



FCW 309LMO

*High productivity 309LMo type
Rutile flux cored wire*

Classification

AWS A5.22 : E309LMoT0-1/-4

ISO 17633-A : T 23 12 2 L R M21(C1) 3

Description & Applications

Rutile flux cored wire for gas shielded (Ar + CO₂ or 100% CO₂) arc welding for stainless steel 309L type alloyed with Molybdenum and for heterogeneous assembly with stainless steel and low alloy steel with service temperature up to +350°C. Especially used to the downhand and horizontal positions.

Main applications: Welding of stainless steels with similar composition, buffer layer and rebuilding before hardfacing.

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	Nb	Co	P	S	N
Min			0.5	22.0	12.0	2.0						
Max	0.04	1.0	2.5	25.0	14.0	3.0	0.5			0.030	0.025	
Type	0.03	0.80	1.4	23.5	12.5	2.8	0.10	0.01	0.05	0.020	0.008	0.06

All Weld Metal Mechanical Properties

	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
Min	350	550	25	
Max				
Type	610	760	27	+20°C 50

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick out (mm)	
FCAW = +	1.2	100 - 280	23 - 33	10 - 25	ISO 14175 : M21 (Ar + CO ₂) C1 (100% CO ₂) 12-20 l/min
	1.6	150 - 400	23 - 35		



FT En-CN34-240913

Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company Selectarc reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for Selectarc. **Fumes:** Consult information on MSDS, available upon request.

www.selectarc.com - info@selectarc.com